

Work Order ID 71329

Tuesday, June 28, 2011 10:15:07 AM



Page 1

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 11-06-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H

100		0.00
	Skidtubes	
Skidtubes	Memo	0.00
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020	

11-6-28

110		0.00
	BENDING MACHINE - SKIDTUBES	
CNC Bend 1	Memo	0.00
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021	

11-6-28

120		0.00
	QC5- Inspect part completeness to step on W/O	
QC	Memo	0.00
Quality Control		

1 0 BE/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		11/06/29		1			
170 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11-26-29		1			

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Customer:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

SAP 11-06-30

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

WL 11/06/30

7-Transfer drill D3391-021 with D3391-023

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8464130

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00							
Hand Finishing	Memo								
210	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo								
220	Skidtubes	0.00							
	Skidtubes	0.00							
Skidtubes	Memo								
	1-instal spacers as per dwg D3391								
	A/R Magnabond 6398 batch: M116677								
	exp. date: 11/08								
	cure time 12hrs. as per QSI015								
	2- grind crossbolt flush								
	3-back drill crossbolt if necessary								

1 0 SAN 11-06-30

DP 11-6-30

3 OK 11/07/04

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sub 764

235



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

AND REALODINE AS PER PAR09-043

15- BL 71-7-4.

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:15
320 OF
11:45

M117745

IX Ø M-14/07/05

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d 11 10/7/06

255

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG ****

1 26 11 10/7/06

257

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/11

10 11/05/11

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260



Packaging

Identify as per dwg & Stock Location: w/o

0.00

D412

.712-043/B71312

1

0

11/07/06

Memo

0.00

Packaging

280



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/9/19
MK
11-09-19

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Picklist Print

Tuesday, June 28, 2011 10:15:04 AM

Page 1

Work Order ID: 71329

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 6/28/2011

Required Date: 7/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 05.09.13 New issue KJ/JLM
 IPP B 06.02.10 Dwg rev.D ecn 773 EC
 IPP C 06.05.02 Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev J 09.02.02 added hardware EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6013-047 Skidtube Material		Manufactured	No			100	Each	18.0000	1	1			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG	18								
				26547	18								
D3670-4-200 SPACER		Manufactured	No			220	Each	38.0000	4	4			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG	38								
				70822	38								
D3401-041 Tow Cap Assembly		Manufactured	No			255	Each	2.0000	1	1			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				FP007	2								
				61505	2								

DD 11-6-28

DL 11/06/30

4

11/07/06

B71352

X1

W/O:		WORK ORDER CHANGES					
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Tuesday, June 28, 2011 10:15:04 AM

Page 2

Work Order ID: 71329

Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 6/28/2011

Required Date: 7/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13	Manufactured	No	255	Each	16.0000	1	1
							<u>21</u> 11/07/06
Wearshoe							

Location

Loc Qty

Loc Code



FP016

16

69280

16

1

D3566-13	Manufactured	No	255	Each	26.0000	1	1
							<u>21</u> 11/07/06
Gasket							

Location

Loc Qty

Loc Code

FP

24

69281

24

21



FP014



2

68341

2

21

AN960C10L	<u>NAS1149C0332</u>	Purchased	No	255	Each	0.0000	10	10
	<u>R</u>						<u>21</u> 11/07/06	
washer								

AN3C4A		Purchased	No	255	Each	2,162.000	10	10
							<u>21</u> 11/07/06	
BOLT								

Location

Loc Qty

Loc Code

ST350

2162

117313

2

117688

776

117795

500

117872

22

118012

500

118112

362

21

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Page 3

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Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 6/28/2011

Required Date: 7/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

255

Each

1,122.000

4

4



Handwritten: 11/07/06

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1096

64177

596

66821

500

ST077

26

52505

26

AELS-1032-130

Purchased

No

255

Each

0.0000

2

2



Handwritten: (x2) 11/07/06

INSERT

AELS-1032-225

Purchased

No

255

Each

0.0000

10

10



Handwritten: (x10) 11/07/06

INSERT

Handwritten: 11/07/06

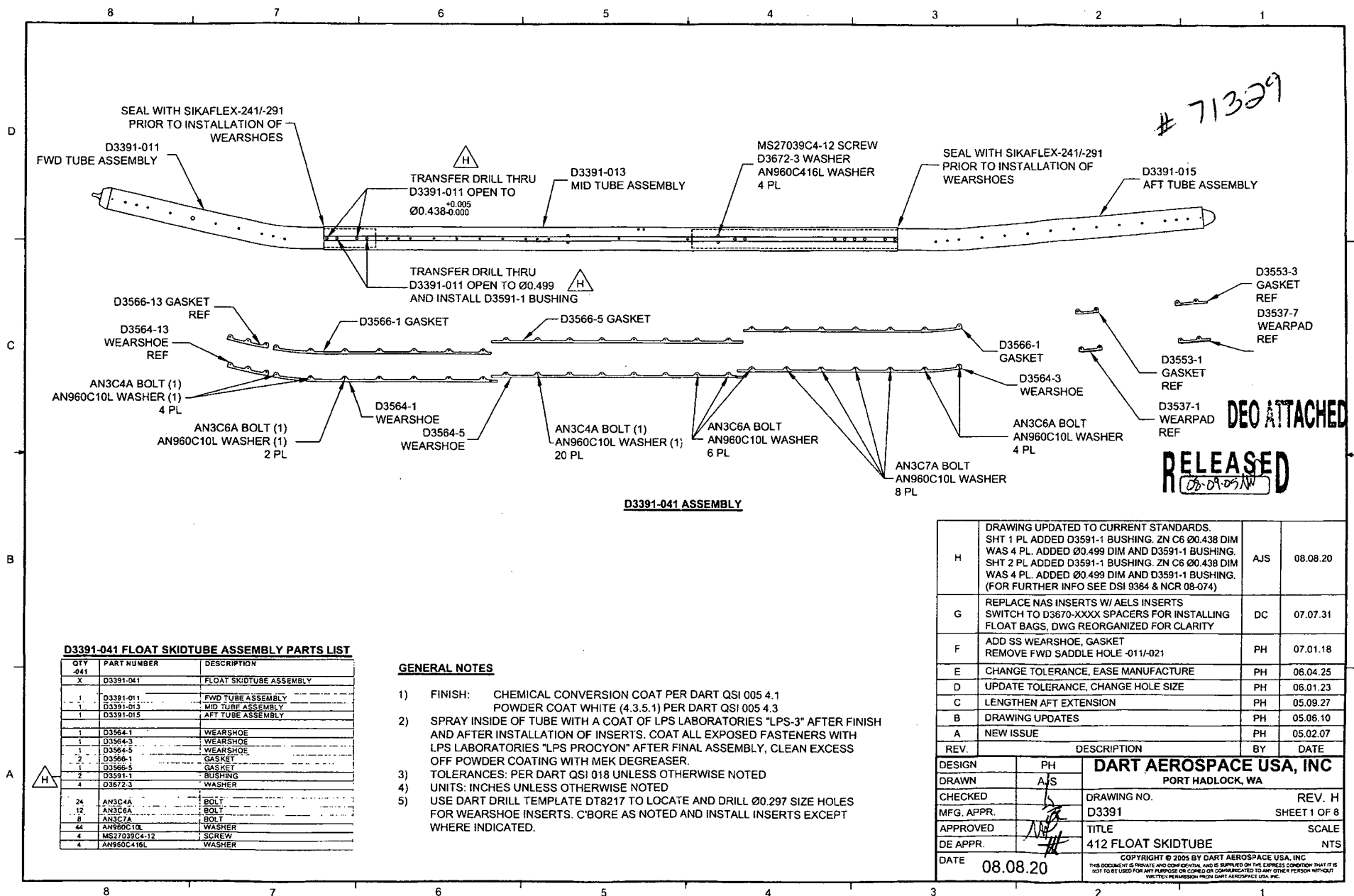
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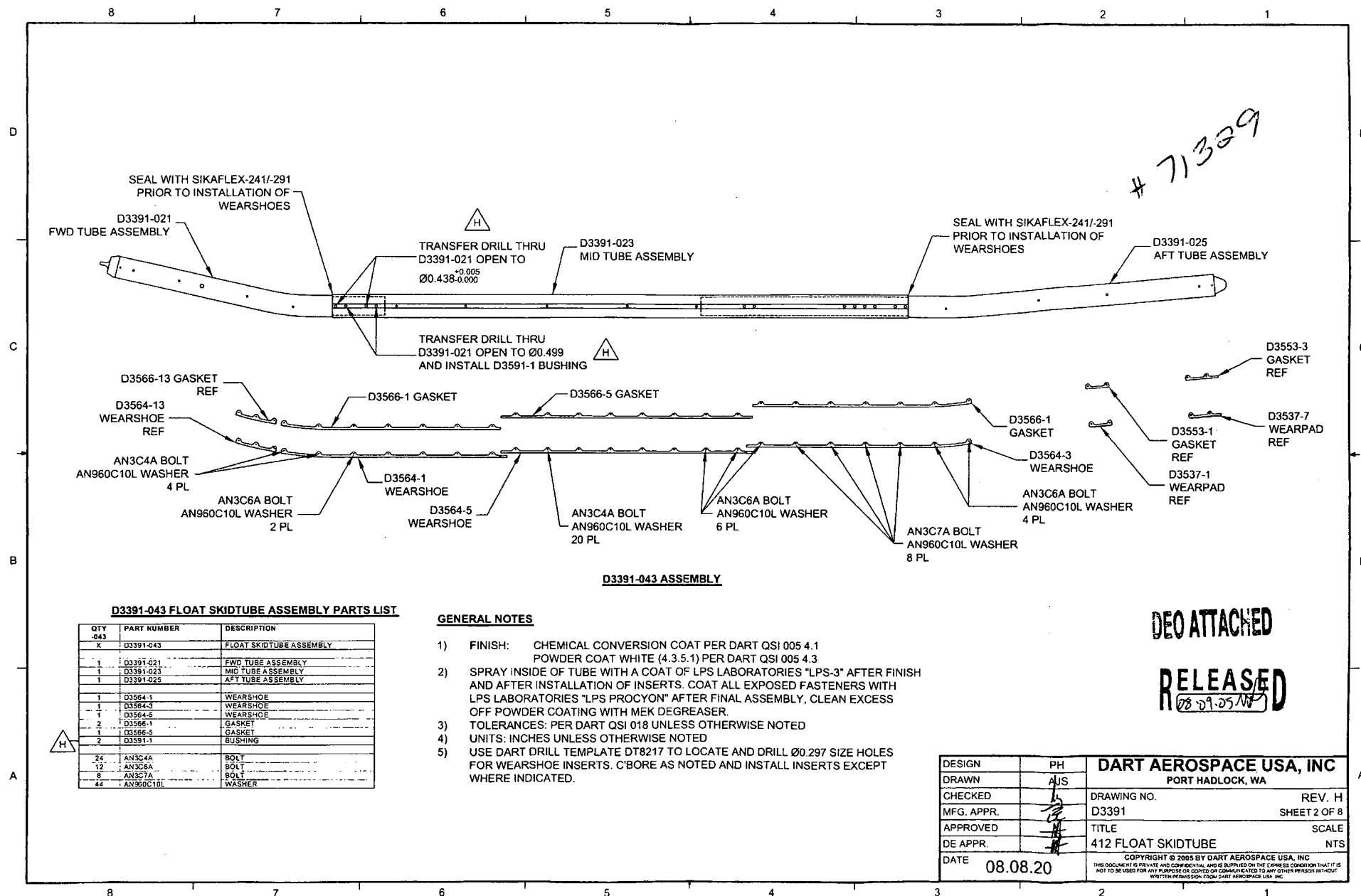
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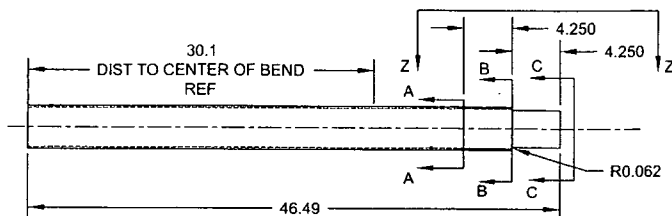
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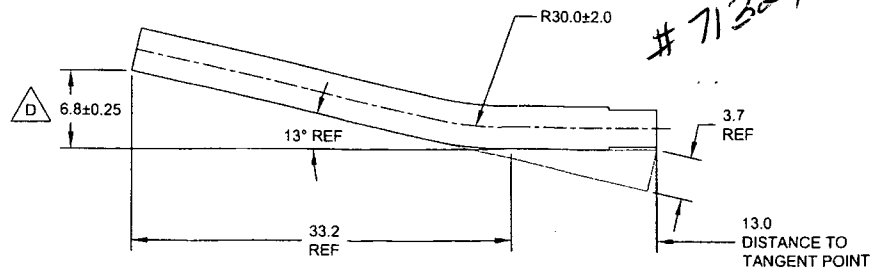
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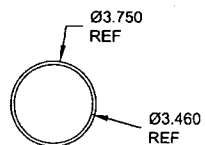
NOTE: Date & initial all entries



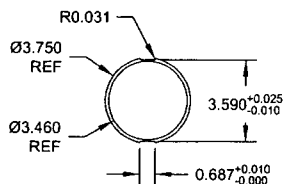
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



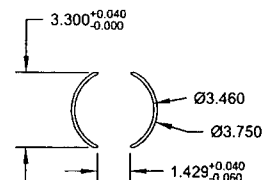
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



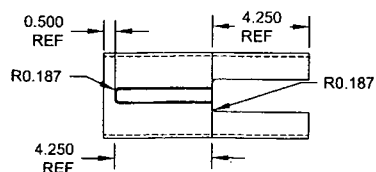
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
28 JAN 05 NW

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H SHEET 3 OF 8
MFG. APPR.		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

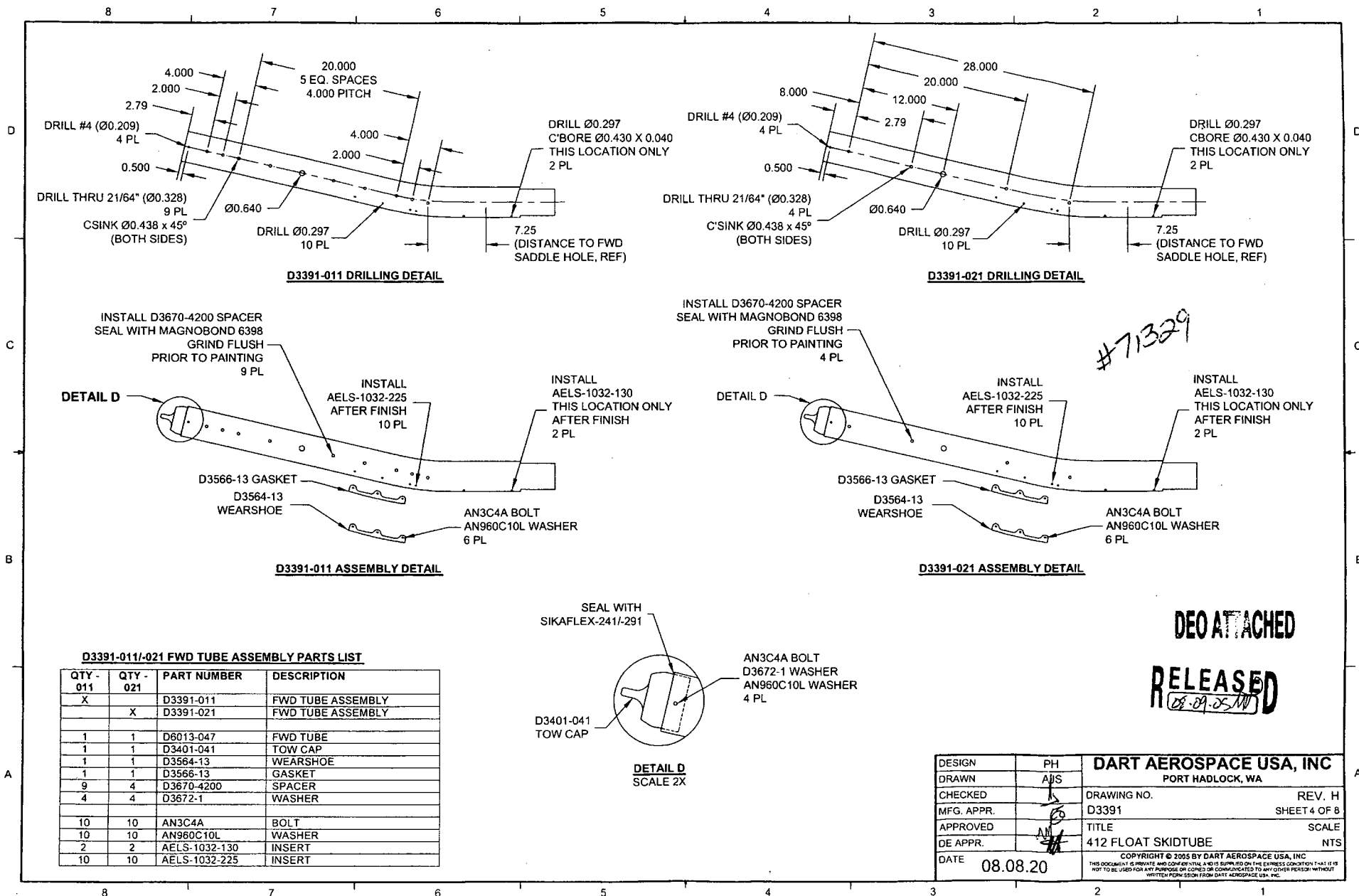
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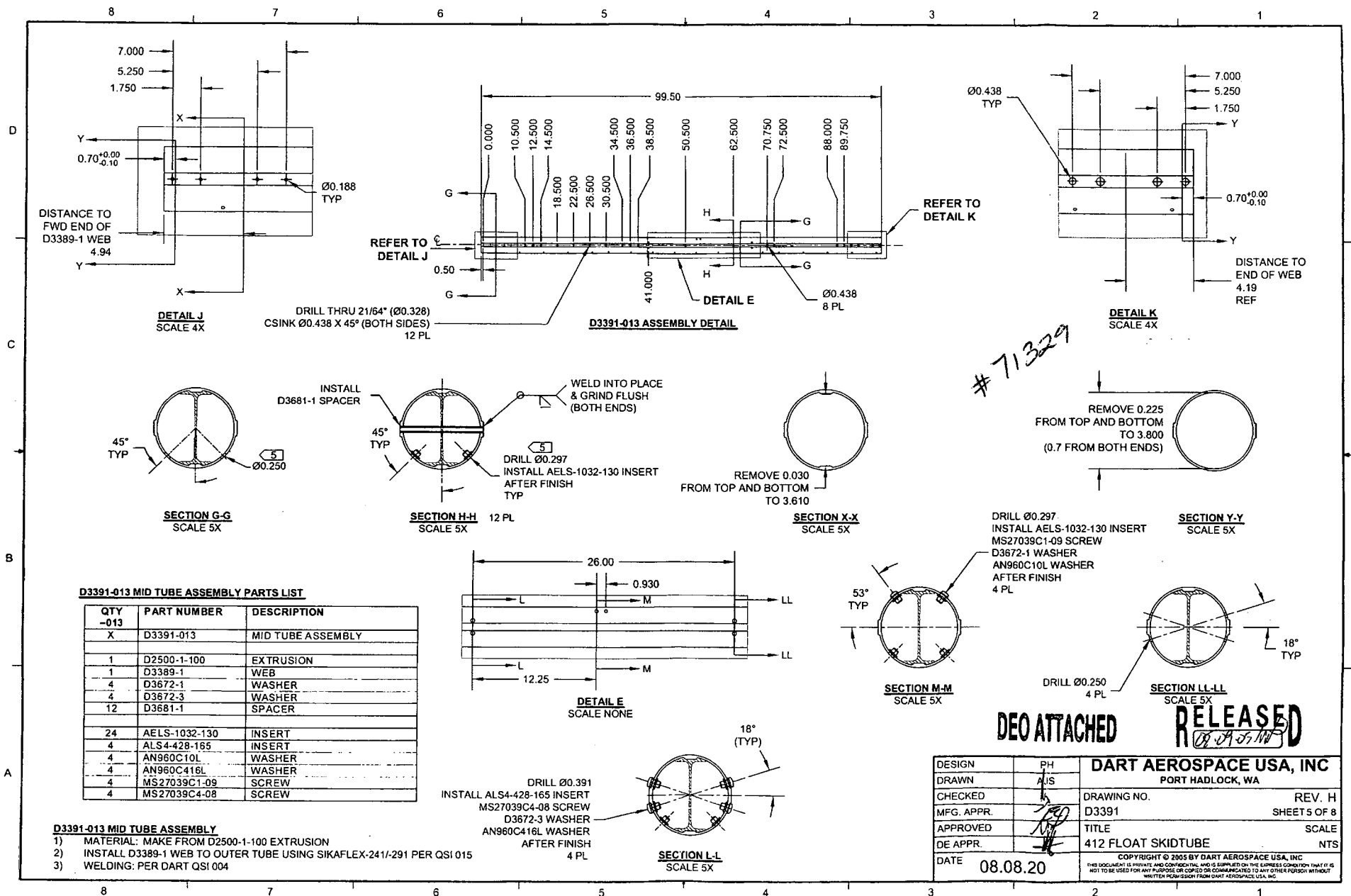
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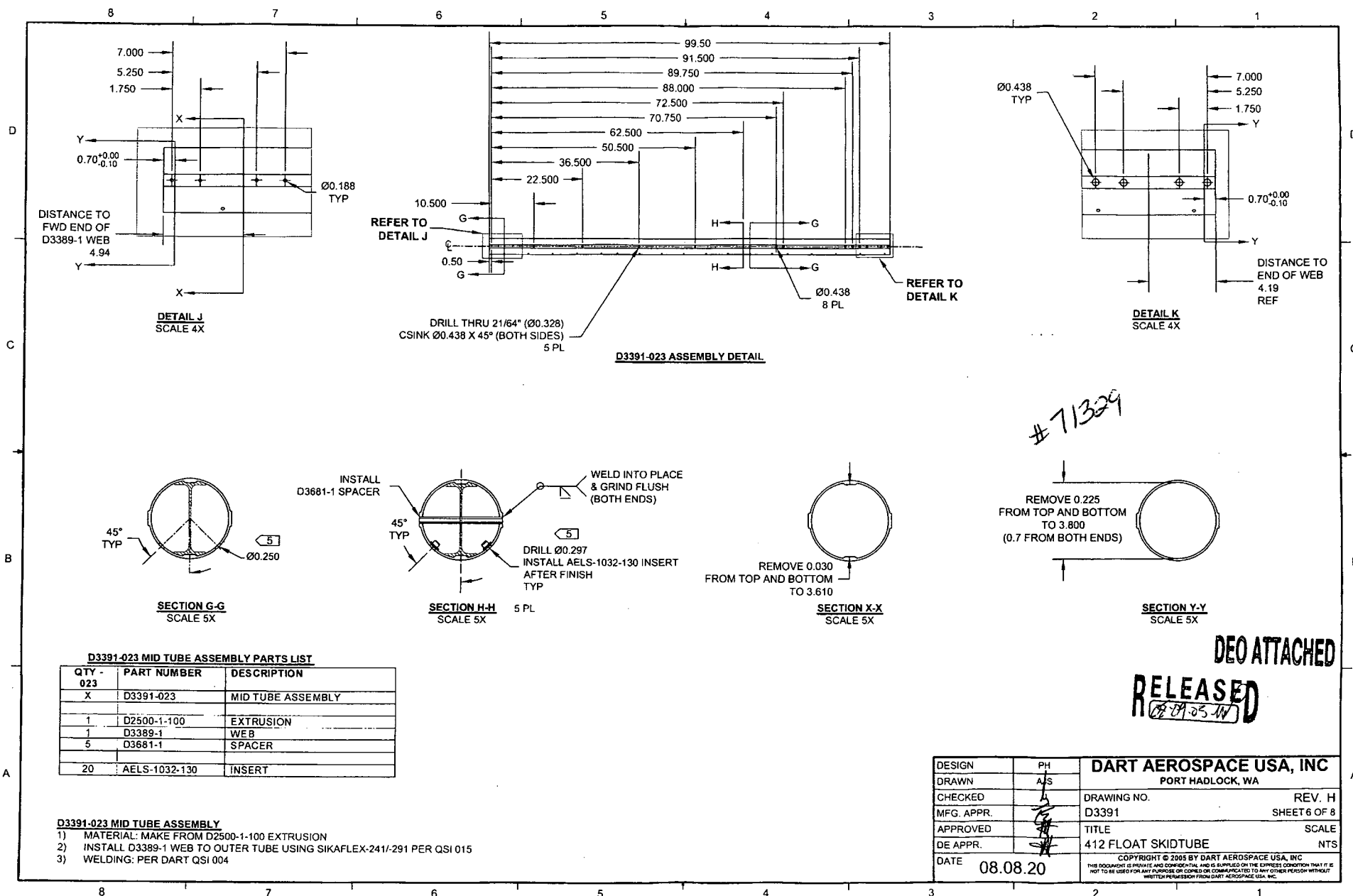
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DEO ATTACHED
RELEASED
08-09-2014

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

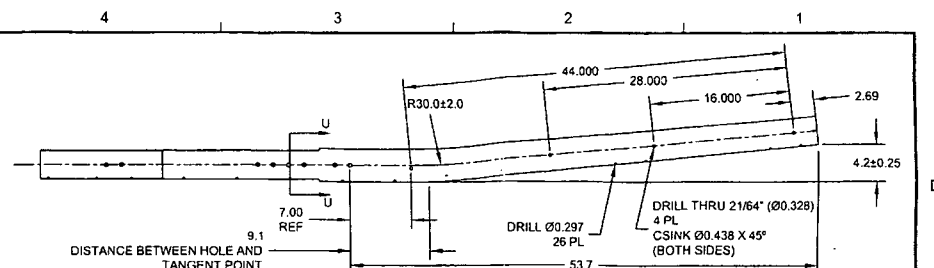
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

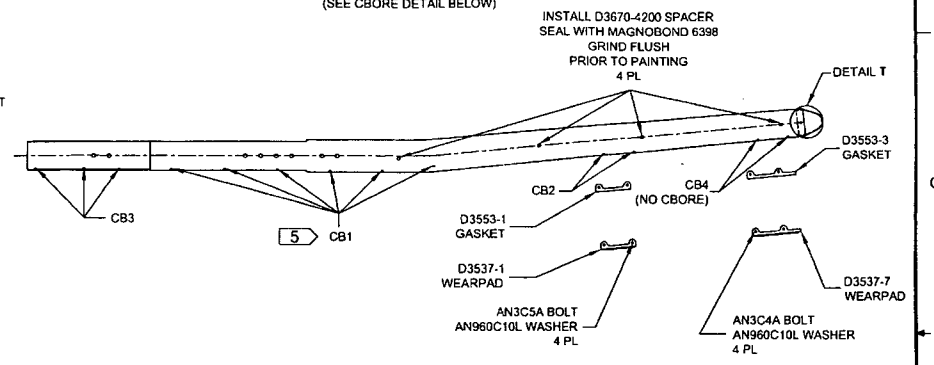
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



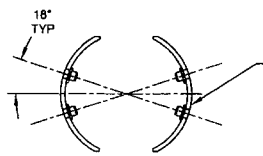
D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



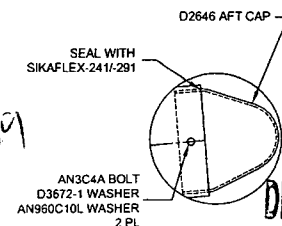
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

03391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

SECTION U-U
SCALE 3X



SECTION CC-CC
SCALE 3X



DETAIL T
SCALE 4X

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NT
DATE 08.08.20		COPYRIGHT © 2003 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS UNCLASSIFIED AND THE RIGHTS HEREIN ARE GRANTED TO THE PUBLIC ON THE CONDITION THAT IT NOT BE USED FOR ANY PURPOSES OR COMMERCIALIZED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

DEO ATTACHED

DETAIL I
SCALE 4X

RELEASED
08-09-05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>MM</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 09.09.23	DATE 04.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

#71329

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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